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D3043-042
Job Sheet 209398



Part No: D3043-042

Job Qty: 8 pcs

Part Name: Step Weldment RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/28/20

Job Tracking No:

Due Date: 11/24/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev :A New Issue JLM 05-11-01

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	8 pcs			0.00	2.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 5	8 pcs			0.00	0.00	QC 5 - 10		SEP 04 2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		

Plex 4/28/20 2:04 PM Dart.lajeunesse.marie

		QC 5 - 82	
120 Large Fab - Steps - 2 - B4B	8 pcs	0.00 5.33	Large Fab - 1 - B4B
			Large Fab - 10 - B4B
			Large Fab - 2 - B4B
			Large Fab - 3 - B4B
			Large Fab - 4 - B4B
			Large Fab - 5 - B4B
			Large Fab - 6 - B4B
			Large Fab - 7 - B4B
			Large Fab - 8 - B4B
			Large Fab - 9 - B4B
			Large Fab - 11 - B4B (Various)
			Large Fab - 12 - B4B
130 QC 9	8 pcs	0.00 0.00	QC 9 - 10
			QC 9 - 18
			QC 9 - 24
			QC 9 - 43
			QC 9 - 50
			QC 9 - 9
140 QC 5	8 pcs	0.00 0.00	QC 5 - 10
			QC 5 - 12
			QC 5 - 17
			QC 5 - 18
			QC 5 - 19
			QC 5 - 22
			QC 5 - 24
			QC 5 - 3
			QC 5 - 43
			QC 5 - 49
			QC 5 - 51
			QC 5 - 58
			QC 5 - 68
			QC 5 - 9
			QC 5 - 50
			QC 5 - 30
			QC 5 - 40
			QC 5 - 61
			QC 5 - 81
			QC 5 - 82
150 Handfinish - 1-1 Chemical- B4B	8 pcs	0.00 1.33	Handfinish - 1 - 1 - B4B
			Handfinish - 1 - 2 - B4B
			Handfinish - 1 - 3 - B4B
			Handfinish - 1 - 4 - B4B
			Handfinish - 1 - 5 - B4B
			Handfinish - 1 - 6 - B4B
			Handfinish - 1 - 7 - B4B
			Handfinish - 1 - 8 - B4B
			Handfinish - 1 - 9 - B4B
			Handfinish - 1 - 10 - B4B
			Handfinish - 1 - 11 - B4B
			Handfinish - 1 - 12 - B4B
			Handfinish - 1 - 13 - B4B
			Handfinish - 1 - 14 - B4B
			Handfinish - 1 - 15 - B4B
			Handfinish - 1 - 16 - B4B
			Handfinish - 1 - 17 - B4B
			Handfinish - 1 - 18 - B4B
			Handfinish - 1 - 19 - B4B

CL 9/9/20

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24 SEP 09 2020
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24 SEP 09 2020
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160 Large Fab - Steps - 3 - B4B	8 pcs	0.00 4.00	Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
			Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
170 QC 10	8 pcs	0.00 0.00	Large Fab - 12 - B4B	
			QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	
			QC 10 - 43	
			QC 10 - 50	
			QC 10 - 58	
			QC 10 - 9	
			QC 10 - 68	
			QC 10 - 81	
180 QC 5	8 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
190 Handfinish - 6-1- Touch Up- B4B	8 pcs	0.00 1.33	Handfinish - 6 - 1 - B4B	
			Handfinish - 6 - 2 - B4B	
			Handfinish - 6 - 3 - B4B	
			Handfinish - 6 - 4 - B4B	
			Handfinish - 6 - 5 - B4B	
			Handfinish - 6 - 6 - B4B	
			Handfinish - 6 - 7 - B4B	
			Handfinish - 6 - 8 - B4B	
			Handfinish - 6 - 9 - B4B	
			Handfinish - 6 - 10 - B4B	
			Handfinish - 6 - 11 - B4B	
			Handfinish - 6 - 12 - B4B	
			Handfinish - 6 - 13 - B4B	
			Handfinish - 6 - 14 - B4B	

			Handfinish - 6 - 15 - B4B	
			Handfinish - 6 - 16 - B4B	
			Handfinish - 6 - 17 - B4B	
			Handfinish - 6 - 18 - B4B	
			Handfinish - 6 - 19 - B4B	
			Handfinish - 6 - 20 - B4B	
			Handfinish - 6 - 21 - B4B	
			Handfinish - 6 - 22 - B4B	
210 Powdercoat - 1 White GI(A)- B4B	8 pcs	0.00 2.00	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
220 Handfinish - 3-1- WingWalk- B4B	8 pcs	0.00 4.00	Handfinish - 3 - 1 - B4B	
			Handfinish - 3 - 2 - B4B	
			Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	
230 QC 3	8 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
			QC 3 - 87	
240 Packaging 3-1 - Stock - B4B	8 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	

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START: 0:10 O.V.T: 320° FINISH: 0:40

20-09-28

8:30

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			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	DAS
			Packaging 3 - 25 - B4B	72
			Packaging 3 - 26 - B4B	9-89
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	OCT 08 2020
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
250 QC 21 - SA	8 pcs	0.00 0.00	QC 21 - SA - 21	DAS OCT 09 2020
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-89

Part Op 100 - Fabricate per Drwg)1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup
 Descriptions: DT8185-G 2-Debur and bevel ends for welding

110 - (QC6- All purchased or subcontracted products)

120 - 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808 AR AL ROD

Batch: 5139019 2-Grind Fwd End Cap weld flush

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (Fabricate per Drwg)1-1-Weld 1 End Cap as per QSI 004 & Dwg AR AL ROD Batch: 1139019 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Touch up alodine)

210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-START Time: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____

220 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

230 - QC3- Inspect Part Finish)

240 - Identify as per dwg & Stock Location: _____

250 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	8 pcs (1 ea)	100-Large Fab - Steps - 1	5269726
D2734	Step End Plate	16 pcs (2 ea)	100-Large Fab - Steps - 1	12x 5286347/5 267496
D3040-1	Mounting Lug	16 pcs (2 ea)	100-Large Fab - Steps - 1	5266117 5259367
D3040-3	Mounting Lug	16 pcs (2 ea)	100-Large Fab - Steps - 1	5268043

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	8	267	0
	D2734	16	60	0
	D3040-1	16	80	0
	D3040-3	16	68	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S298262



Part: D3043-042

Job No: 209398

Serial No/Batch: S298262

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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